

Date: Tuesday, 5/16/2006 10:41:02 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number	: 27149		
Estimate Number	: 10834		
P.O. Number	: NIA	Part Number	: D29332
This Issue	: 5/16/2006 S.O. No. : NIA	Drawing Number	: D2933 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NIA Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 26369	Material	: NIA
Written By	: <i>See Comment Below</i>	Due Date	: 6/5/2006 Qty: 6 Um: Each
Checked & Approved By	: <i>06-05-16 N</i>		
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: <i>B25342</i></p>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<p>Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr</p>		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
<p>Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet</p>		
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
<p>Comment: INSPECT ALL DIM TO DIM SHEET</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/06/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/16/2006 10:41:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 27149

Part Number: D29332

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Int 06/06/12

6

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JAD 06/06/12

6

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/12

(6)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

C 206/20/06

(6)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 475*

C 206/20/06

(6)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

206/06/12

6

Job Completion



u 206-71

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 27149
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.116	.120	.120	.119		
B	0.100	0.140		.117	.120	.121	.120		
C	0.100	0.140		.122	.130	.128	.129		
D	0.210	0.230		.223	.225	.226	.225		
E	1.245	1.255		1.249	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.249	1.250	1.249		
G	2.495	2.505		2.500	2.500	2.501	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.578		
J	2.495	2.505		2.501	2.500	2.501	2.501		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.239	.238	.239	.239		
N	0.100	0.140		.122	.126	.126	.126		
O	0.540	0.560		.550	.550	.550	.551		
P	0.490	0.510		.501	.501	.503	.504		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.258	.257	.257	.258		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.629	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.366		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.125	1.145		1.133	1.135	1.135	1.136		
Y	1.565	1.585	DT8695 A/B	/	/	/	/		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	06/06/11

Audited by:	ML
Date:	06/06/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	

DART AEROSPACE LTD	Work Order:	27149
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. B		Page 1 of 1

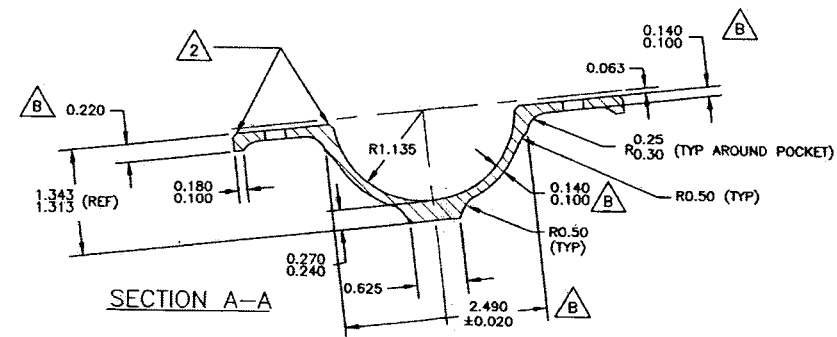
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.119	.119				
B	0.100	0.140		.118	.119				
C	0.100	0.140		.128	.126				
D	0.210	0.230		.228	.227				
E	1.245	1.255		1.250	1.249				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.499				
H	0.510	0.515		.514	.514				
I	1.572	1.582		1.578	1.576				
J	2.495	2.505		2.501	2.500				
K	0.257	0.262	DT8683	/	/				
L	0.312	0.317	DT8686	/	/				
M	0.235	0.240		.240	.239				
N	0.100	0.140		.126	.127				
O	0.540	0.560		.551	.551				
P	0.490	0.510		.505	.503				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.500	2.500				
S	0.240	0.270		.258	.258				
T	0.100	0.180		.145	.145				
U	1.625	1.635		1.630	1.629				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321	DT8690	/	/				
X	1.125	1.145		1.136	1.135				
Y	1.565	1.585	DT8695 A/B	/	/				
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L
Date:	06/06/12

Audited by:	JML
Date:	06/06/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#



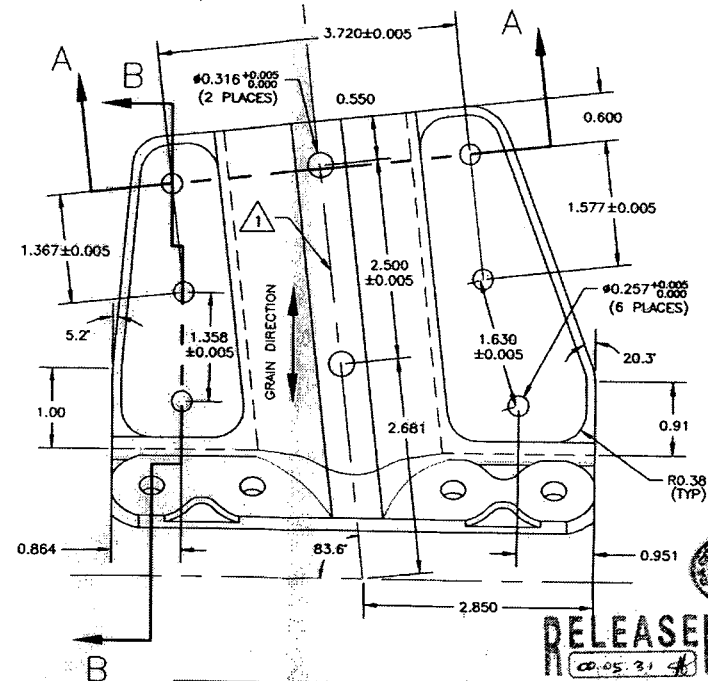
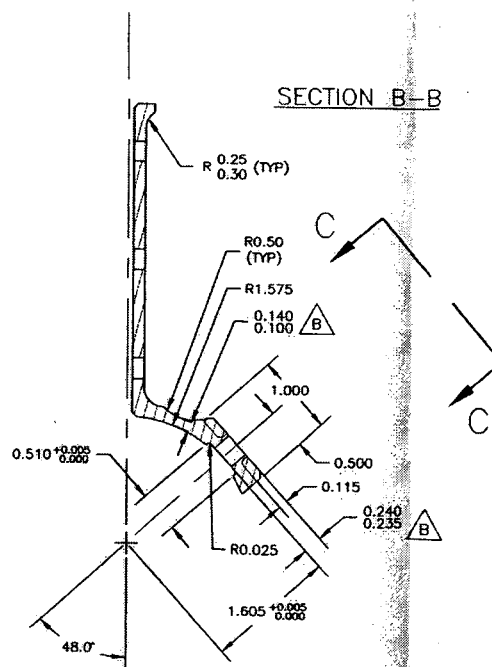
VIEW C-C

SECTION B-B





D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°



RELEASED
00-05-31

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN 	DRAWN BY RF	 DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED 	APPROVED 	
DATE	00.05.29	DRAWING NO. D9233
		TITLE SADDLE INSIDE
		REV. 1 OF SHEET 1 OF SCALE 2:

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WORK ORDER
NO. 27149